

Date: Thursday, 5/4/2006 11:19:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHUT-OFF VALVE SHAFT
Job Number : 26986	
Estimate Number : 12193	
P.O. Number : N/A	Part Number : D3470041
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3470 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 26267	Material : N/A
Written By : <u>See A COMMENT BELOW</u>	Due Date : 5/28/2006
Checked & Approved By : <u>JA 06.05.05</u>	Qty: <u>2</u> <u>8</u> <u>11m</u> Each
Comment : est rev A 06.04.20 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34703	ARM
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3470-3	ARM	B 26115

2.0	D34701	SHAFT
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3470-1	Shaft	B 27014

SB 06/06/07 (2)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3470

AA 06/06/07 (2)

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

PD 06-06-07 (2)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5441

06/06/08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 11:19:21 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 26986

Part Number: D3470041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/08 (2)

Job Completion



u de de 08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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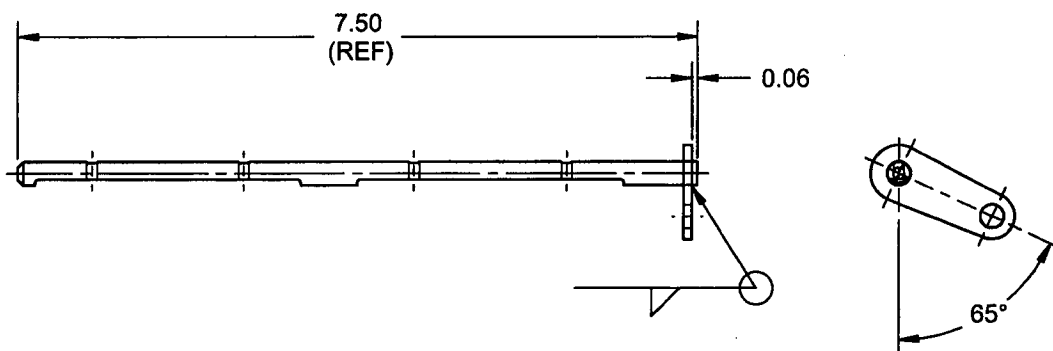
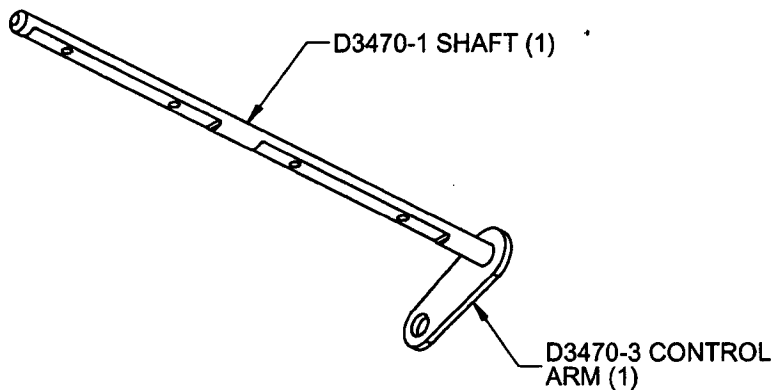
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2
A	05.12.14	NEW ISSUE	



D3470-041 SHUT-OFF VALVE SHAFT

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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WORK ORDER

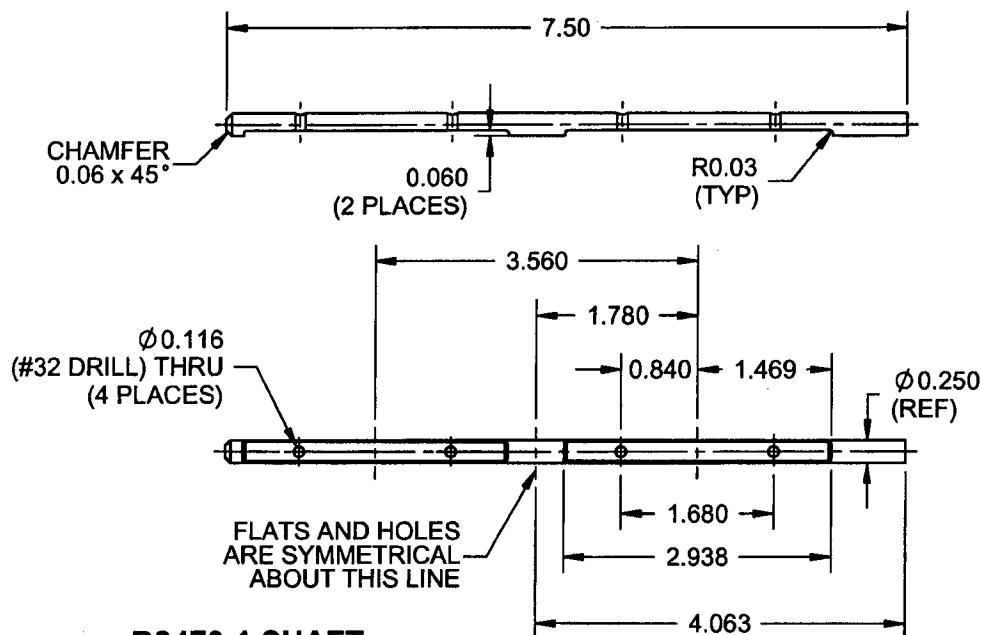
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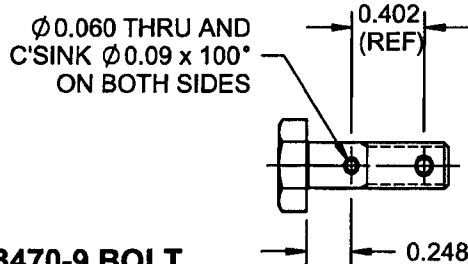
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)

**D3470-9 BOLT**

SCALE 1: 1

- 1) MAKE FROM AN4-6 BOLT

NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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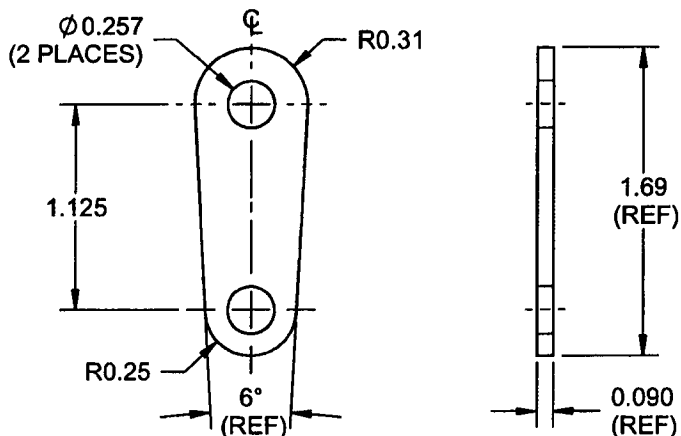
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

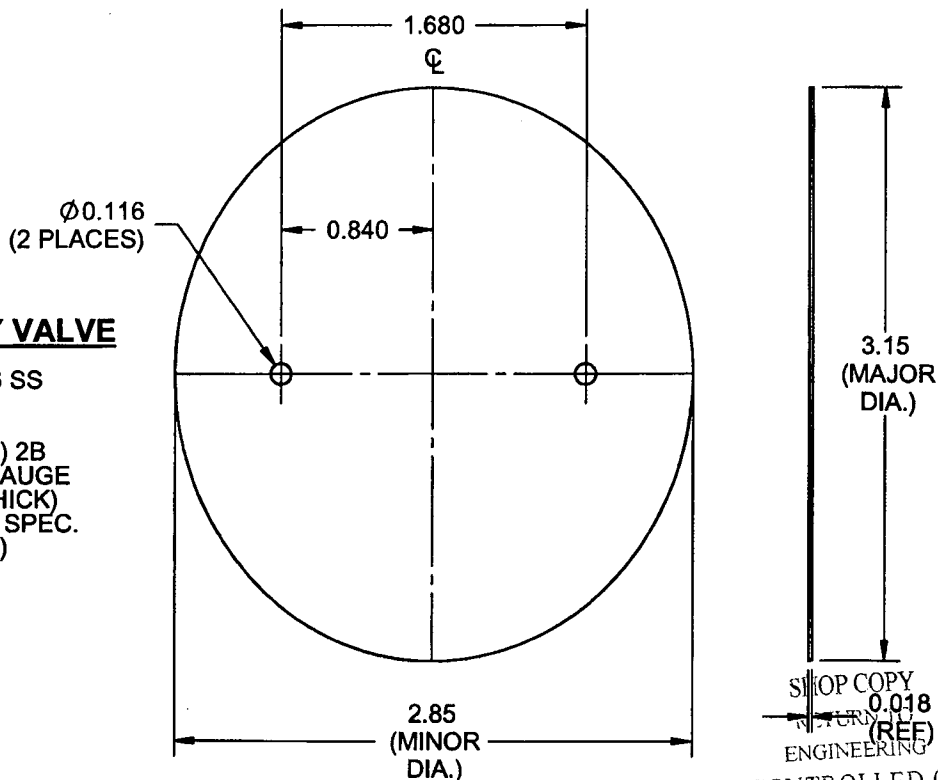
D3470-3 CONTROL ARM

1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3470-5 BUTTERFLY VALVE

1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



NOTES:

2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

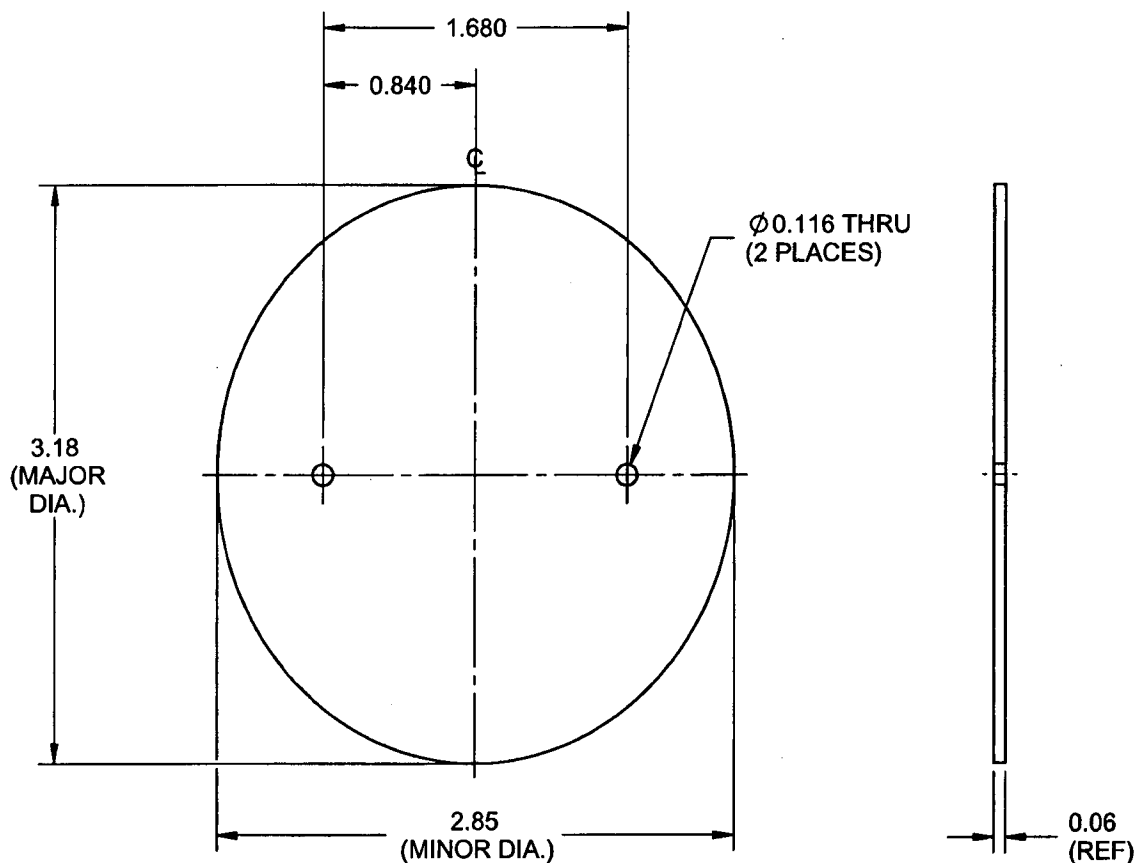
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT SCALE 1:1	



D3470-7 BUTTERFLY VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.04.03 *[Signature]*

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